

Date: Tuesday, 1/3/2006 4:14:49 PM
 User: Kim Johnston

Process Sheet

SPILT-2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 25346 -2	
Estimate Number : 10033	
P.O. Number :	
This Issue : 1/3/2006 S.O. No. :	Part Number : D6101003
Prsht Rev. : NC	Drawing Number : D6101 REV A
First Issue : / /	Project Number : N/A
Previous Run : 24891	Drawing Revision : A
	Material :
Written By :	Due Date : 1/30/2006
Checked & Approved By :	Qty: 100 Um: Each
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 00000339

SP 06/01/04

a) Description: Aluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

3.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CNC

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25346

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Aug. 07.17

Job Completion



U 06-07.17

E
F
T
P
F
P
W
C
C
A

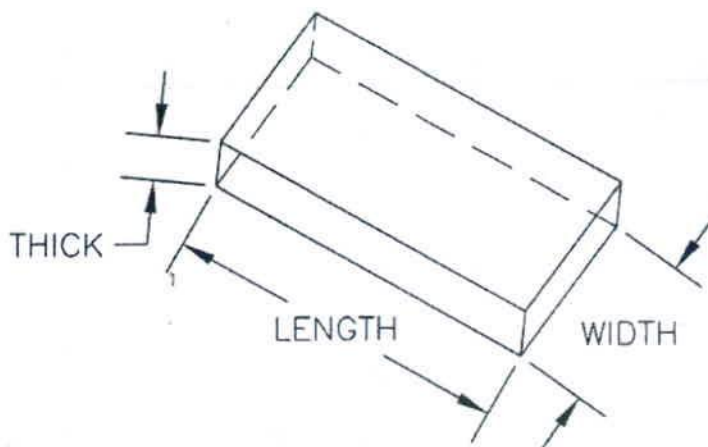
Jo



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>AS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CP*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

31 533682 604824 01

A.M. CASTLE & Co. (Canada) Inc. **SHIPPED JUL 13 2006**

533682

1. REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPTÉ-ACCT.

VEND. SLS

TERR.

EXPÉDIE PAR-SHIP VIA

PO 00000339

91037

200

40

CABANO (PPD)

ACHETEUR-PURCHASING AGENT

TELEPHONE

H/C

TAXE

NO. COM. ORD.

REGION LIVRAISON-DEL. ZONE

F.A.B.-F.O.B.

BILL

NO. FEVILE/EMBALLAGE-B/L NUMBER

LINDA LACELLE

613 632-3336

9

0

1 C/O

PREPAID

A105424

/RÉ A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

INFORMATION CRÉDIT-CREDIT INFORMATION

R2C SEE FRANCE STATUS

ROUTE

01-NL-04/2

30-NL-05/0

31-NL-07/1

INSTRUCTIONS/LIVRAISON-DELIVERY

INQ-B29602

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.0000 PLATE 7075-T7351 ALUM 6.25" X 7.875"

BLACK W/RED STRIPE

CERTIFICATE OF CONFORMANCE

INSTRUCTIONS

A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon.

A.M. Castle & Co. (Canada) Inc.

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.



TOL: +.025"/-.000"

SKID: TYPE 3A

GRAIN TO RUN ALONG 7.875"

THICKNESS TOL.: +.030"/-.000"

ATTN MARTINE: PAS AVANT 13 JUIL

COULÉE INFO-HEAT INFO QTE-QTY

347756A9

QTE/UNITE COM.-ORDERED

POIDS COM.-WT. ORDERED

52 PCS

PCS

517

BALLOTS-BUNDLES

PCES/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

1

52

517

FORME-SHAPE

I.A.C.

6857

29.000000

INSTRUCTIONS (CONT'D.)

52 x 6.25" x 7.875"

ENT.-WT.

DESCRIPTION - ITEM 2

**TERMS AND CONDITIONS
OF SALE****SEE DISCLAIMERS AND LIMITATIONS
ON THE REVERSE SIDE**

INSTRUCTIONS

1 Box

COULÉE INFO-HEAT INFO QTE-QTY

QTE/UNITE COM.-ORDERED

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

INSTRUCTIONS (CONT'D.)

DESCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

QTE/UNITE COM.-ORDERED

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

INSTRUCTIONS (CONT'D.)

NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-
DATE RECEIVEDFEVILLE D'EMBALLAGE - PACKING SLIP
C.M.D.

SHIP TO:

A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

SOLD TO:

AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4064387

CUSTOMER PO NUMBER: 01-82184		WORK PACKAGE:	CUSTOMER PART NUMBER: 8857		SHIP RUN/LOAD ID: 100649/14	GOV'T CONTRACT NUMBER: A97075-60
KAISER ORDER NO: 1033615	LINE ITEM: 1	SHIP DATE: 13-APR-2006	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	
WEIGHT SHIPPED: 1436 LB	QUANTITY: 1 PCS EST.	B/L NUMBER: 208073	GAUGE: 2.0000 IN	WIDTH: 48.500 IN	LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev04
BSS 7055/RevA
EAC MS1011/RevA
MMS 159/RevN

AMS-QQ-A-250/12
ASTM B 594/Rev02
CSTI 006/RevB
GSS16100/RevG
PS 21211/RevJ

AMS-STD-2154
BAC 5439/RevH
DPS 4.713/RevN/AmdAF
MIL-STD-2154

Test Code: 4297

Test Results

Lot: 347756A9 Cast 884

Drop 71

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.4 : 74.0 (506 : 510)	62.0 : 62.3 (427 : 430)	11.2 : 11.4

Conductivity %IACS :	39.5 Min	40.1 Max
(MS/M) :	22.9 Min	23.3 Max

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.24	1.54	0.05	2.50	0.20	5.68	0.03	0.01	0.01	TOT 0.01

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP

DATE REC'D 4.18.06 IAC 6857

APPROVED BY: [Signature]

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4064387

TEST NOTES

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR



